



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4202-1
Job Sheet 180916



Part No: D4202-1

Job Qty: 300 ea

Part Name: Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/17/18

Job Tracking No:

Due Date: 8/3/18

Created By: Jesse White

Type: Stock

Description:

Note: DWG REV C IPP REV:A NEW ISSUE 10-12-07 JLM VERIFIED:DD IPP REV:B AS PER REV B 11-04-05 JLM
VERIFIED BY:DD IPP Rev:C 11.12.19 PER DWG REV.C DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	300 Ea		8/3/18	0.00	0.00	Start Up Machining-2		18/3/17 JBD
100	Hardinge	300 pcs		8/3/18	0.00	12.77	Hardinge		18/5/17 JBD
120	QC	300 pcs		8/3/18	0.00	0.00	QC8		
130	Outsource	300 pcs		8/3/18			MEI001-VC	9	18/8/18 JBD
140	Packaging	300 pcs		8/3/18	0.00	0.00	Packaging2		AUG 20 2018
150	QC	300 pcs		8/3/18	0.00	0.00	QC6		
160	HandFinish	300 pcs		8/3/18	0.00	1.50	HandFinish4		18/8/18 JBD
190	Packaging	300 pcs		8/3/18	0.00	0.00	Packaging3-2		
200	QC21-SA	300 Ea		8/3/18	0.00	0.00	QC21		AUG 24 2018

Part Op 100 - 1- Machine as per Folio FB015 ***DO NOT CHAMFER OUTSIDE DIA***
Descriptions: 130 - ***HEAT TREAT AS PER DWG D4202*** Mat'l: 6061-T6 Aluminum Tubing Per WWT-700/6
160 - WASH SPACER AS PER QSI005
190 - ***STOCK IN SKIDTUBE CELL***

D0040717 - Metzger

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6T0.500W.058	6061-T6 Round Tube .500 X.058W	105 ft (.35 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6T0.500W.058	105	205	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	0.500inches $\pm$ 0.010	0.510 0.490	Product	
2	Spacer	0.058inches $\pm$ 0.010	0.068 0.048	Product	
3	Spacer	4.145inches + 0.030 - 0.010	4.175 4.135	Product	

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Container No: S099431



Part: D4202-1

Job No: 180916

Serial No/Batch: S099431

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/07/18

8105 0 5 3018



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040717**

Supplier: MEI001-VC
Metcor Inc.
560 Boul. Arthur Sauve
Saint-Eustache
QC
J7R 5A8 Canada
Phone: 450 473 1884
Fax: 450 491 5498

PO No: PO040717
PO Date: 8/10/18
Due Date: 8/17/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, Chrisoula
Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	177503	C3-12-4	Lock Roller 1--Issue P/O to Metcore ; P/O _____ RC 53-56 2-Bead blast 3- Certificate of Conformity is required ***NOTE*** DROP SHIP TO FINISHER Metcore to ship directly to Groupe Altech***	Firmed	-	8/17/18	39 pcs	0 pcs	39 pcs	\$7.6923076/pcs	\$300.00
2	180916	D4202-1	Spacer : Various STC's ***HEAT TREAT AS PER DWG D4202*** Mat'l: 6061-T6 Aluminum Tubing Per WWT-700/6	Firmed	-	8/17/18	300 pcs	0 pcs	300 pcs	\$2.225/pcs	\$667.50
Grand Total:											\$967.50

Order Notes

CT

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/13/18 2:28 PM dart.tsimiklis.chrisoula

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉDITION Shipper
329586	1	130228

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



LIVRÉ À /Shipped To

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No.	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
040717		AL-6061	2018/8/10	CLIENT

QUANTITÉ Quantity	No. PIÈCE Part No.	NOM DE LA PIÈCE Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight
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300 D4202-1
(300) D4202-1
JOB 180916

11,15

1 BOITE DE CARTON

TYPE DE CONTENEUR Container Type	# DE CONTENEURS # Of Containers	COMMENTAIRES CONTENEUR Container Comments
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BOITE DE CARTON

1

CERTIFICAT

EMPAQUETAGE Packing	
------------------------	--

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 300

POIDS EXPÉDIÉ / Weight Shipped : 11,15

QUANTITÉ RESTANTE / Quantity Remaining : 0

POIDS RESTANT / Weight Remaining : 0,00

APPROUVE

CERTIFICAT

QUANTITÉ EXPÉDIÉE / Quantity Shipped: 300

POIDS EXPÉDIÉ / Weight Shipped : 11,15

Signature:

Date:

EXPÉDIÉ LE / Shipped On : 2018/08/17

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détail

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
329586	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
040717	N/A	AL-6061		
SPÉCIFICATIONS DU PROCÉDÉ processing specifications SOL ANNEAL SINGLE AGING TO CONDITION T42				
EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results	
CONDUCT	36 - 44 %IACS	60 (60 Khz)	40 - 42 %IACS	
HARDNESS	60 HREW MIN	60	64 - 67 HREW DURETE MESUREE EN HR15TW = 64,5-66,3 HR15TW	
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
300	11.15	D4202-1 (300) D4202-1 JOB 180916 1 BOITE DE CARTON		

COMMENTAIRES / comments

SOL. ANNEAL 985F, 30 MIN
AGE HARDEN AMBIANT 96 HRS

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification. All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

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Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée. Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

Ce document et les documents qui lui sont joints peuvent contenir des informations confidentielles, être soumis aux réglementations relatives au contrôle des exportations ou ayant un caractère privé. S'ils ne vous sont pas destinés, nous vous signalons qu'il est strictement interdit de les divulguer, de les reproduire ou d'en utiliser de quelque manière que ce soit.

DAS
38
9-89

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détail

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
329586	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

le contenu. Toute exportation ou réexportation non autorisée est interdite.

APPROUVÉ par / Approved by:

Isabel Otero

Isabel Otero
QA Technician



DATE: 2018-08-17

DAS
38
9-89

1911-1912
1913-1914

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

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Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
329586	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

COMMANDE DU CLIENT client order	CLASSIFICATION PIÈCE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contract	PROGRAM program
D40717	N/A	AL-6061		ad Jauuon

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

SOL ANNEAL

SINGLE AGING TO CONDITION T42

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
CONDUCTIVITY	38 - 44 %IACS	60	40 - 42 %IACS
HARDNESS	60 HREW MIN	60	64 - 67 HREW
DURETE MESUREE EN HR15TW = 64,5-66,3 HR15TW			

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
300	11,15	D4202-1 (300) D4202-1 JOB 180916 1 BOITE DE CARTON

COMMENTAIRES / comments

APPROUVÉ par / Approved by:

Pierre Piché
Chief Inspector



23 Août
DATE: 2018-08-17

Chief Inspector
Plate Ridge
METCOR
6

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
329586	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
040717	N/A	AL-6061		

SPÉCIFICATIONS DU PROCÉDÉ processing specifications

SOL ANNEAL

SINGLE AGING TO CONDITION T42

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
CONDUCTIVITY	38 - 44 %IACS	60	40 - 42 %IACS
HARDNESS	60 HREW MIN	60	64 - 67 HREW
DURETE MESUREE EN HR15TW = 64,5-66,3 HR15TW			

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
300	11,15	D4202-1 (300) D4202-1 JOB 180916 1 BOITE DE CARTON

COMMENTAIRES / comments

APPROUVÉ par / Approved by:

DATE: 2018-08-17

Pierre Piché
Chief Inspector



APPROUVÉ

Certificat de Conformance
Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
329286	1

METCOR INC.

500 BUL. ARTHUR-SAUVE, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884
Télécopieur / Fax administration: 450-491-2498
Télécopieur / Fax production: 450-491-0424

CLIENT / customer: 219
DART AEROSPACE
1270 ABERDEEN
HAWKESBURY

LIVRÉ À / shipped to:
DART AEROSPACE
1270 ABERDEEN
HAWKESBURY

ON K8A 1K7

ON K8A 1K7

COMMANDE DU CLIENT customer po	CLASSIFICATION PIÈCE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
040717	N/A	AL-8081		
SOL ANNEAL SINGLE AGING TO CONDITION T42 SPECIFICATIONS DU PROCÉDÉ processing specifications				

EXIGENCE / requirement	SPECIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	80 HREW MIN	80	84 - 87 HREW
CONDUCTIVITY	38 - 44 %IACS	80	40 - 42 %IACS
DURETE MESUREE EN HR15TW = 84,5-88,9 HR15TW			

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
300	11,15	D4202-1 (300) D4202-1 JOB 180918
		1 BOITE DE CARTON

COMMENTAIRES / comments

APPROUVÉ par / Approved by:

DATE: 2018-08-17

Chief Inspector
Pierre Fichet
METCOR

APPROUVÉ